

Date: Thursday, 2/9/2006 1:37:28 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                                                 |                  |                          |
|-----------------------|-----------------------------------------------------------------|------------------|--------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services                           | Drawing Name     | : 350/212/130 BASKET LID |
| Job Number            | : 25754B                                                        |                  |                          |
| Estimate Number       | : 10193                                                         |                  |                          |
| P.O. Number           | : N/A                                                           | Part Number      | : D2512                  |
| This Issue            | : 2/9/2006                                                      | S.O. No.         | : N/A                    |
| Prsht Rev.            | : NC                                                            | Drawing Number   | : D2512 REV D1           |
| First Issue           | : N/A                                                           | Project Number   | : N/A                    |
| Previous Run          | : 25440B                                                        | Drawing Revision | : D1                     |
|                       |                                                                 | Material         | : N/A                    |
| Written By            | : <u>See comment below</u>                                      | Due Date         | : 2/28/2006              |
| Checked & Approved By | : <u>06-02-10</u>                                               | Qty:             | 1 Um: Each               |
| Comment               | : Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/<br>RF |                  |                          |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |                |                          |
|-----|----------------|--------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: M 100138
06/03/02

|     |        |             |
|-----|--------|-------------|
| 2.0 | D31663 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3166-3 Basket Hoop

Batch

B 25896
06/03/02

|     |       |         |
|-----|-------|---------|
| 3.0 | D2506 | Placard |
|-----|-------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2506 Label Plate

Batch

B 24875
06/03/02

|     |        |                |
|-----|--------|----------------|
| 4.0 | D23271 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2327-1 Bushing

Batch

B 24873
06/03/02

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 2/9/2006 1:37:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 25754B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B23445

11/06/03/02

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B25139

11/06/03/02

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M100071

11/06/03/07

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.  
EC130 Basket only

Pick:

Qty Part Number

Description

Batch

2 D2012-117 Clevis

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

11/06/03/07

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *PD*   Date:   8/03/13  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 2/9/2006 1:37:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 25754B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-03-07

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/09

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

SPRAY: 19640

Batch: M10037

ML 06-03-09

12.0

QC3

INSPECT-POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-03-09  
26/03/13

Job Completion



U 06-03-13

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

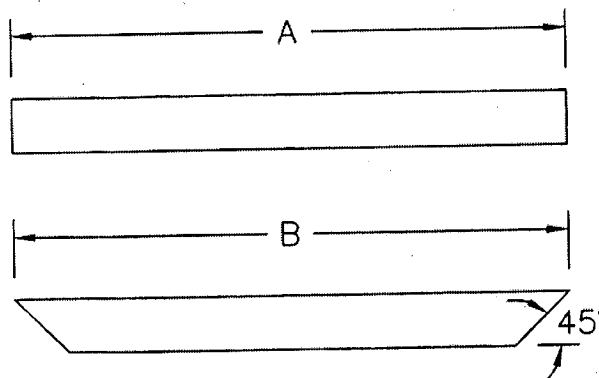
**NOTE:** Date & initial all entries

**DART**

|                  |                |                                                                |                        |
|------------------|----------------|----------------------------------------------------------------|------------------------|
| DESIGN<br>BW     | DRAWN BY<br>CP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA              |                        |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D2512                                           | REV. D<br>SHEET 1 OF 4 |
| DATE<br>01.04.19 |                | TITLE<br>BASKET LID ASSEMBLY (350/212)<br>SCALE<br>NTS         |                        |
| A                | 95.11.21       | NEW ISSUE                                                      |                        |
| B                | 96.05.24       | ADDED LATCH CHANNEL & LABEL PLATE                              |                        |
| C                | 99.07.06       | REMOVE DOUBLE SKIN SECTION,<br>ADDED MEMBERS, INCORP. DEO 9074 |                        |
| D                | 01.04.19       | CHANGE HINGE                                                   |                        |
| D1               | CP 03.01.20    | ADD D2012-117 FOR D130-701-041                                 |                        |
| D2               | CP 04.09.20    | TACK WELD ANT-SKID AREA                                        |                        |

**RELEASED**  
01.04.27 #**PARTS LIST FOR D2512 BASKET LID ASSEMBLY**

| PART NO | QUANTITY | LENGTH<br>A | LENGTH<br>B | DESCRIPTION   |
|---------|----------|-------------|-------------|---------------|
| D2512-1 | 2        | —           | 25.50       | RIB           |
| D2512-3 | 2        | —           | 95.30       | RIB           |
| D2512-5 | 6        | 30.84       | —           | RIB           |
| D2512-7 | 3        | 30.63       | —           | RIB           |
| D2232-1 | 2        | N/A         | N/A         | HINGE PLATE   |
| D2236   | 4        | N/A         | N/A         | RIB           |
| D2327-1 | 2        | N/A         | N/A         | BUSHING       |
| D2506   | 1        | N/A         | N/A         | LABEL PLATE   |
| D2581   | 2        | N/A         | N/A         | MOUNTING BRKT |

D2512-1/-3/-5/-7

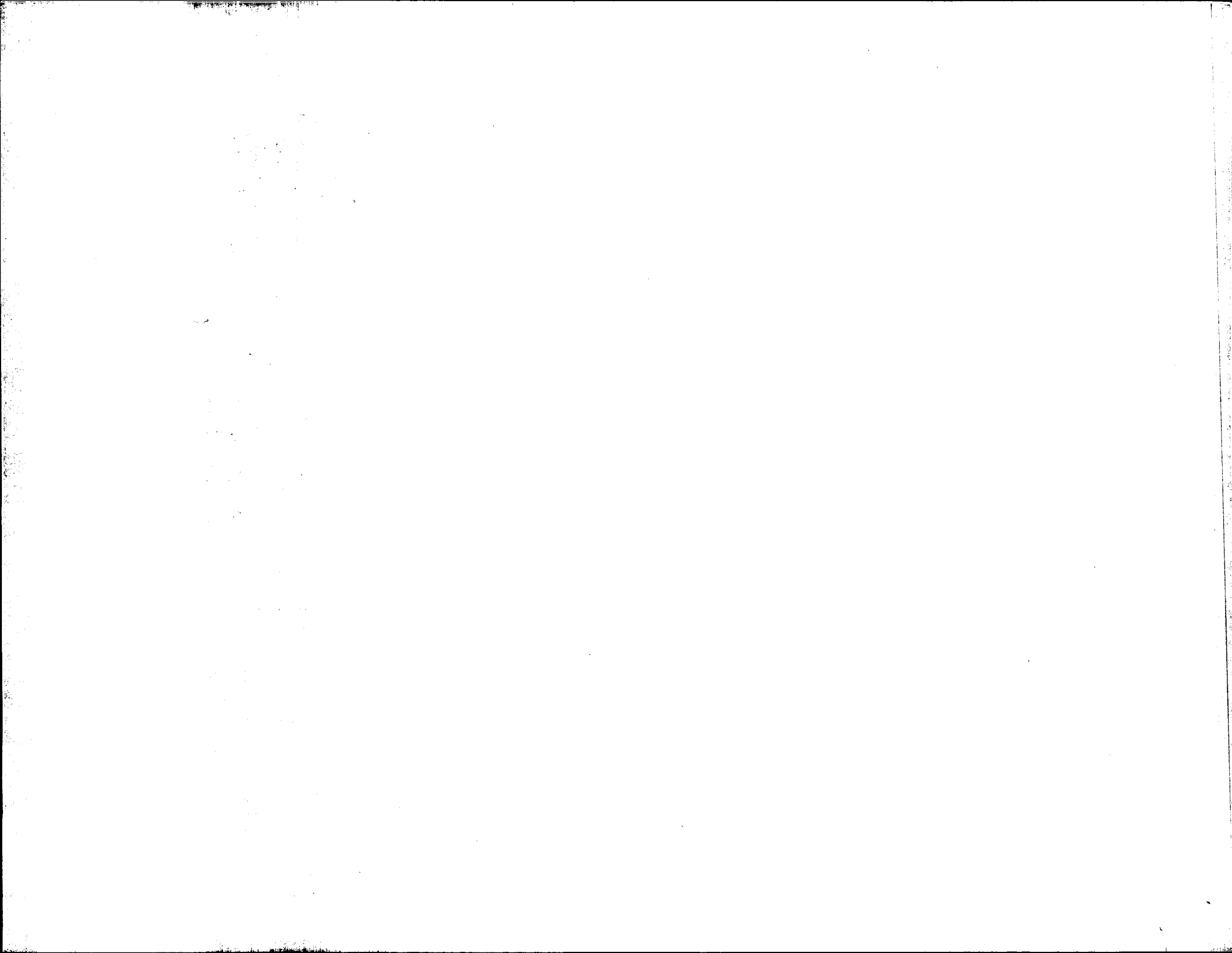
CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHESSHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICEWORK ORDER  
NO. 25754B

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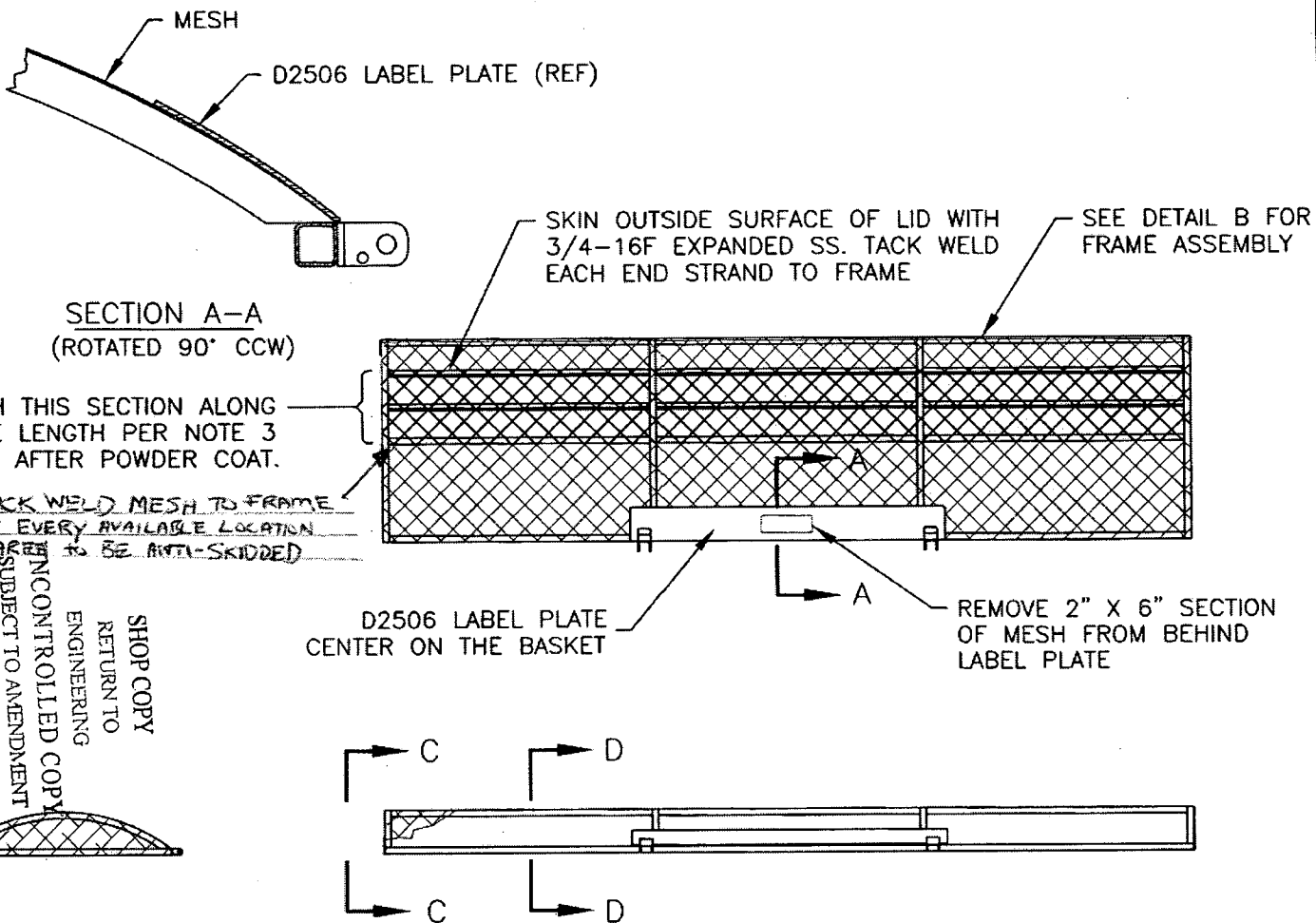
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**DART**

|         |          |             |                               |                             |
|---------|----------|-------------|-------------------------------|-----------------------------|
| DESIGN  | BW       | DRAWN BY    | CP                            | DART AEROSPACE LTD          |
| CHECKED |          | APPROVED    |                               | HAWKESBURY, ONTARIO, CANADA |
| DATE    | 01.04.19 | DRAWING NO. | D2512                         | REV. D                      |
|         |          | TITLE       | BASKET LID ASSEMBLY (350/212) | SHEET 2 OF 4                |
|         |          | SCALE       | 1:20                          |                             |



#### D2512 BASKET LID ASSEMBLY

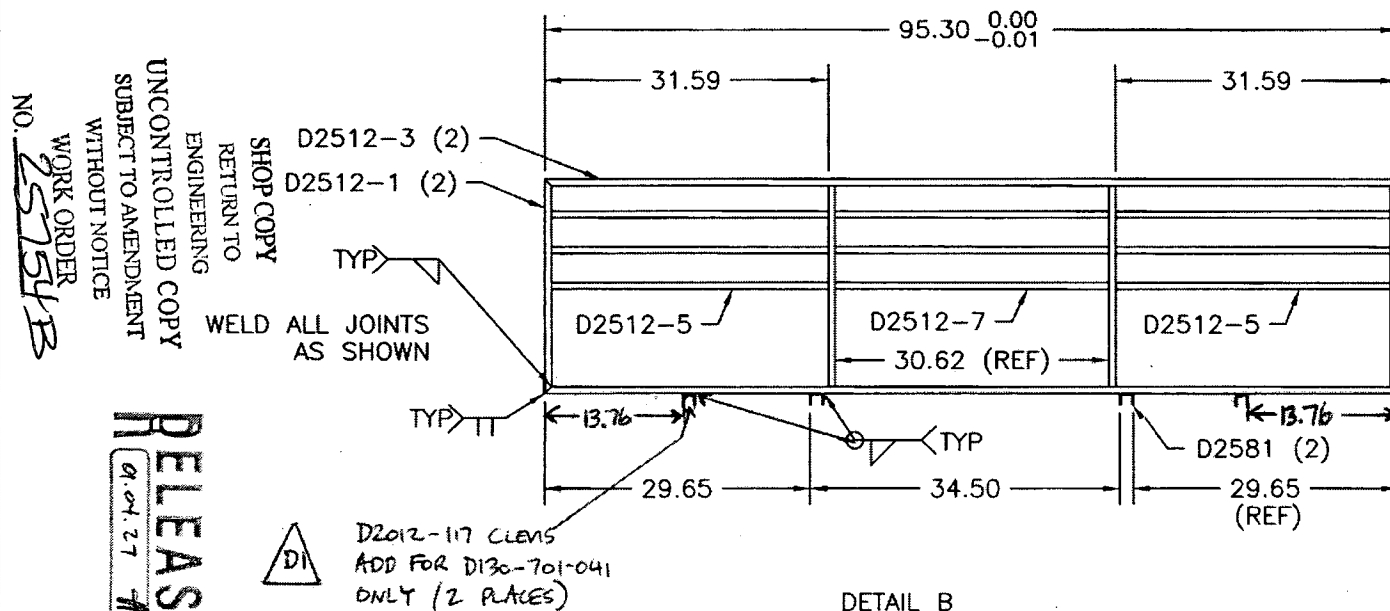
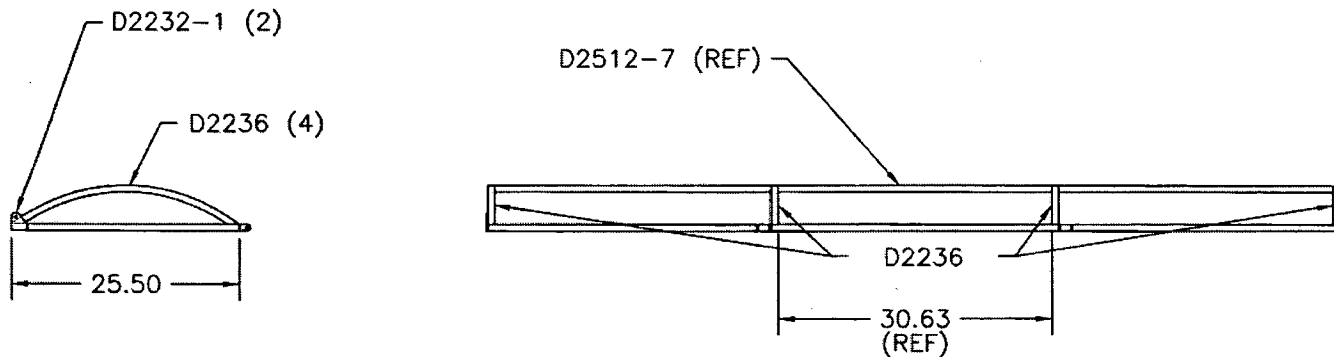
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED  
01.04.27

NO. 25754 B  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY  
UNCONTROLLED COPY  
IN AREA TO BE ANTI-SKIDDED



| DESIGN   | DRAWN BY                      | DART AEROSPACE LTD          |
|----------|-------------------------------|-----------------------------|
| BW       | UP                            | HAWKESBURY, ONTARIO, CANADA |
| CHECKED  | APPROVED                      | DRAWING NO.                 |
| 01.04.19 |                               | D2512                       |
| DATE     | TITLE                         | SHEET 3 OF 4                |
|          | BASKET LID ASSEMBLY (350/212) | SCALE                       |
|          |                               | 1:20                        |



DETAIL B  
FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

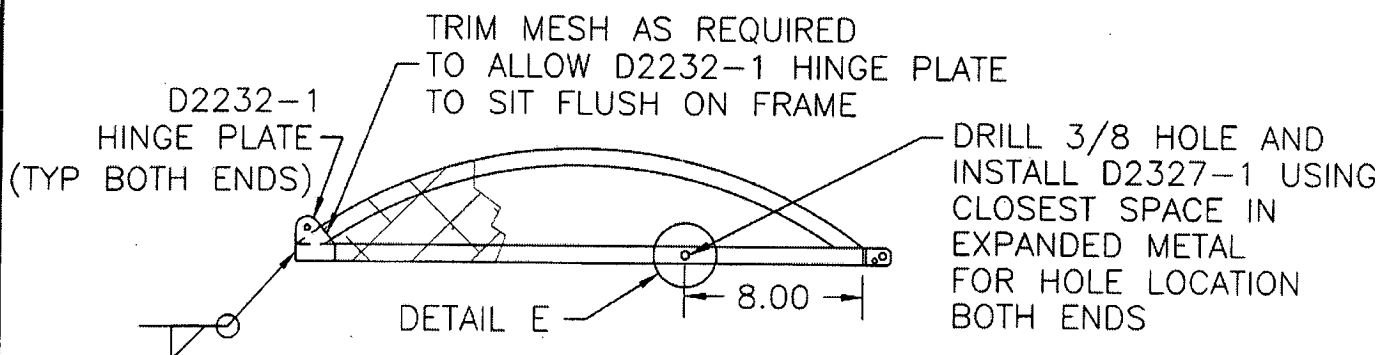
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01.04.27

WORK ORDER  
NO. 25154B

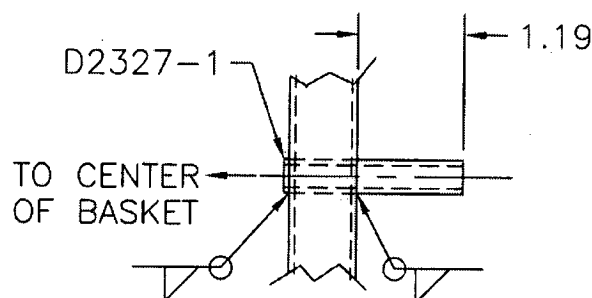
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ENGINEERING  
RETURN TO  
SHOP COPY



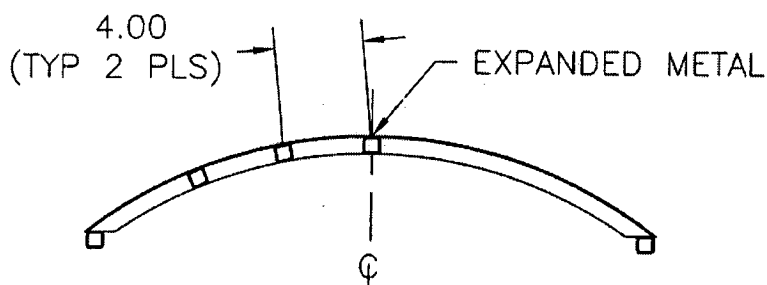
|                  |                |                                                   |                        |
|------------------|----------------|---------------------------------------------------|------------------------|
| DESIGN<br>BW     | DRAWN BY<br>UP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D2512                              | REV. D<br>SHEET 4 OF 4 |
| DATE<br>01.04.19 |                | TITLE<br>BASKET LID ASSEMBLY (350/212)            | SCALE<br>1:8           |



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 25154B  
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01.04.27

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